



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3193-041
Job Sheet 208471



Part No: D3193-041

Job Qty: 30 pcs

DAS
21
9-09

Part Name: Support Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/20/20

Job Tracking No:

Due Date: 4/10/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP Rev:A New Issue 05-11-05 JLM IPP Rev:B Change Rivet Lengh 07-03-19 JLM IPP Rev: C
Step 13 added 08.12.18 KJ Verified by:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	30 pcs		4/10/20	0.00	0.22	Bandsaw - 1		ALA
110	HAAS 4 Axis - B4B	30 pcs		4/10/20	1.00	64.21	HAAS - 1 - B4B HAAS - 2 - B4B HAAS - 3 - B4B HAAS - 4 - B4B		ALA/SC
120	QC 2	30 pcs		4/10/20	0.00	0.00	QC 2 - 1 QC 2 - 12 QC 2 - 14 QC 2 - 17 QC 2 - 19 QC 2 - 2 QC 2 - 20 QC 2 - 22 QC 2 - 23 QC 2 - 25 QC 2 - 32 QC 2 - 33 QC 2 - 35 QC 2 - 39 QC 2 - 4 QC 2 - 40 QC 2 - 44 QC 2 - 45 QC 2 - 48 QC 2 - 49 QC 2 - 50 QC 2 - 51 QC 2 - 52 QC 2 - 57 QC 2 - 62		SC 20-09-31

20/03/28

20/03/29



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CANADA
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Container No: S267254



Part: D3193-041

Job No: 208471

Serial No/Batch: S267254

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/28/20

Plex 3/20/20 11:38 AM Dart.lajeunesse.marie

				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
130	QC 8	30 pcs	4/10/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
140	Handfinish - 1-1 Chemical-B4B	30 pcs	4/10/20	0.00 2.31	Handfinish - 1 - 1 - B4B
					Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B

20-04-04

20-04-06

					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150 Powdercoat - 1 White GI(A)- B4B	30 pcs	4/10/20	0.00	1.89	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	20-04-6
					Powdercoat - 4 - B4B	
160 QC 3	30 pcs	4/10/20	0.00	0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
170 Small Fab - 2 - B4B	30 pcs	4/10/20	0.00	4.53	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
					Small Fab - Various 1 - B4B	
180 QC 5	30 pcs	4/10/20	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	

					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	APR 09 2020
					QC 5 - 61	
					QC 5 - 81	
190 Packaging 3-1 - Stock - B4B	30 pcs	4/10/20	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9 89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 37 - B4B	
200 QC 21 - SA	30 pcs	4/10/20	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9 89

Part Op 100 - (Bandsaw) Cut blanks: 3.500" x 2.500" x 6.00" long Bar
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA374 and Dwg D3193 Identify as D3193-1 2-Deburr and Tumble
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 140 - Chemical Conversion Coat per QSI005 4.1
 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 12:20. FINISH TIME: 12:00. 11255540. OVEN TEMPERATURE: 500°
 160 - QC3- Inspect Part Finish
 170 - (Small Fab) Assemble D3193-041 as per Dwg D3193
 180 - QC5- Inspect part completeness to step on W/O
 190 - Identify as per dwg & Stock Location:
 200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	
M6061T6B2.500X03.500	6061-T6 Bar 2.50 X 3.50	14.7300 ft (491 ea)	100-Bandsaw - 1	5201 Container
MS20426AD3-7-ZV		240 Ea (8 ea)	170-Small Fab - 2 - B4B	5221 813
MS21073L4	Nutplate	120 Ea (4 ea)	170-Small Fab - 2 - B4B	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B2.500X03.500	15	15	0
170-Small Fab - 2 - B4B	MS20426AD3-7	240	5,066	0
	MS21073L4	120	0	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD		Work Order: 208477
Description: Support Bracket		Part Number: D3193-1
Inspection Dwg: D3193	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.435	+/-0.010	3.434			B18017739	VERN.
2.012	+/-0.010	2.011			—	—
1.200	+/-0.010	1.203			—	—
2.006	+/-0.010	2.007			—	—
R0.125	+/-0.010	R.125			R-G	Ref.
2.435	+/-0.005	2.436			B18017739	VERN.
0.281	+/-0.005	.281			—	—
0.264	+/-0.010	.264			—	—
5.878	+/-0.010	5.877			—	—
4.878	+/-0.005	4.878			—	—
2.550	+/-0.010	2.550			—	—
15°	+/-0.5°	15.0°			A-G	CNC-17
0.260	+/-0.010	.259			B18017739	VERN.
R0.05 R.50	+/-0.030	R.50			R-G	Ref.
Ø0.266	+0.006/-0.001	.266			GP	Ref.
Ø0.098	+0.004/-0.001	.098			GP	Ref.
Ø0.180 x 100°	+0.005/-0.001	.183			B18017739	VERN.
0.850	+/-0.010	.850			—	—
R0.125	+/-0.010	R.125			R-G	Ref.
0.255	+/-0.010	.256			B18017739	VERN.
2.812	+/-0.010	2.813			—	—

Measured by: ALA	Audited by: DAS 20 9-89	Prototype Approval:	N/A
Date: 20/03/29	Date: 20-04-04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue P/O D3193-041	KJ/DD	
B	09.05.04	R0.50 was R0.050	KJ/DD	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

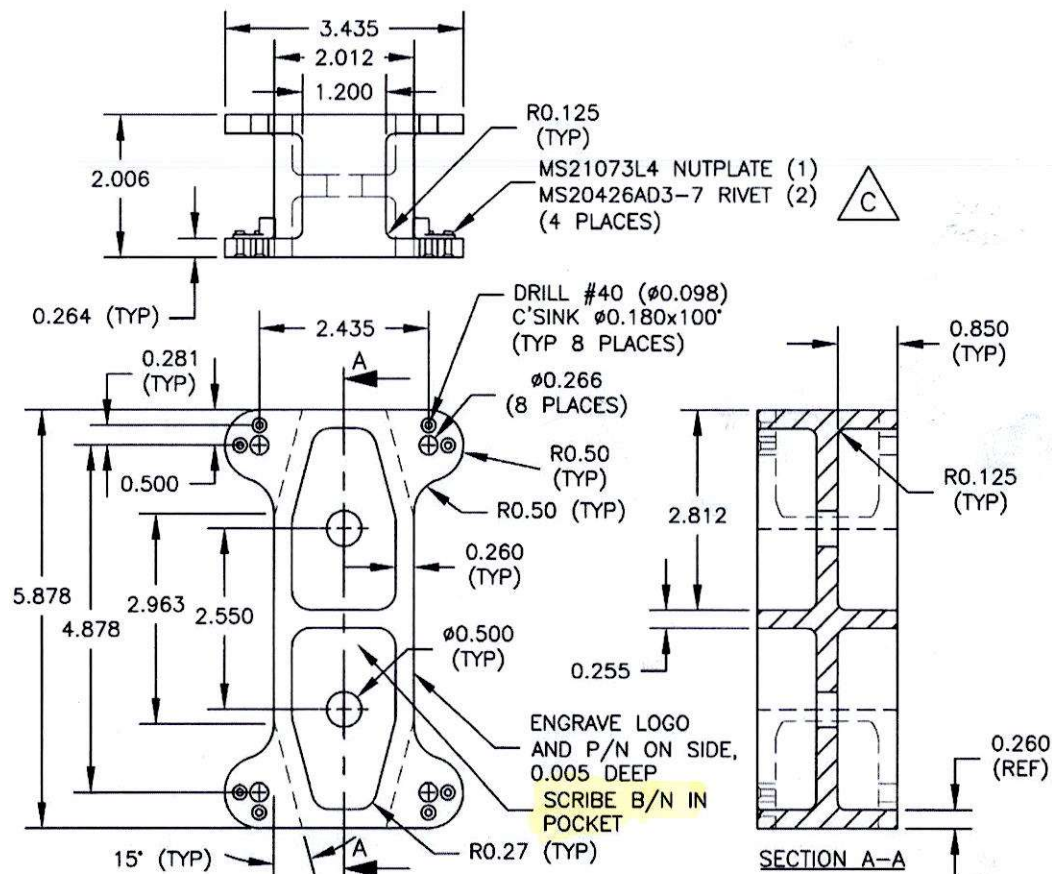
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART

DESIGN UP	DRAWN BY JH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED JH	DRAWING NO. D3193	REV. C SHEET 1 OF 1
DATE 05.09.29		TITLE SUPPORT BRACKET ASSEMBLY	SCALE 1:2
A	03.06.09	NEW ISSUE	
B	03.12.22	MANUFACTURED BY DART	
C	05.09.29	MS20426AD3-7 WAS MS20426AD3-5	

RELEASED
105-01-30**D3193-041 SUPPORT BRACKET ASSEMBLY (D3193-1 SUPPORT BRACKET)**

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-225/8 OR QQ-A-200/8)
(REF DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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